

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009319**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun, Chen Ying Xin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Milling Position West Tower Lift 1 diaphragm to C/D corner diagonal plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSD1-A115F/J-243

WSD1-A115F/J-242 (VT Reject due to arc strike and spatters)

WSD1-A115G/J-120 (MT Reject due to MT linear indications)

WSD1-A115G/J-121, 236, 237

WSD1-A115H/J-118, 119, 230, 231

WSD1-A115J/J-54, 56 (From 38M to 47.6M)

This Quality Assurance (QA) Inspector observed the following work in progress:

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Bay 10

FCAW welding of weld joint 2A located on SSD1-SPSA3-4.

Welder is identified as 048784. ZPMC QC is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SMAW welding of weld joint 8B located on ED1-A6003-5.

Welder is identified as 053049. ZPMC QC is identified as Mr. Chen Ying Xin.

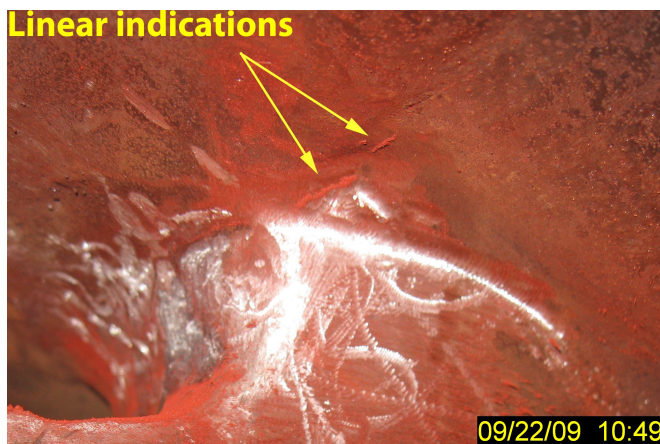
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

During random verification Magnetic Particle Testing of weld WSD1-A115G/J-120 of west tower lift 1 diaphragm to C/D corner diagonal plate located in the milling section, Caltrans Quality Assurance (QA) Inspector discovered two linear indications of approximately 12mm and 4mm in length. This area has been previously tested and accepted by ZPMC NDT personnel. (NDT Inspection Notification sheet # 004261)

During random verification Visual Testing (VT) of West tower lift 1 diaphragm to C/D corner diagonal plate, weld WSD1-A115F/J-242 visually unacceptable due to welding spatter and arc strike found at the Inspection area. ZPMC provided the NDT Inspection Notification sheet # 004261 after repair, informing Caltrans QA that they have completed their NDT requirements after repair.

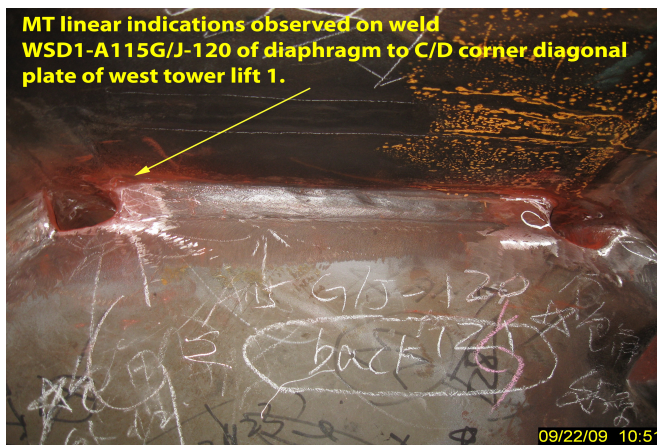
The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
